

Date: Tuesday, 10/2/2007 10:38:42 AM  
 User: Kim Johnston

## Process Sheet

44

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 212/205 HIGH FED X-TUBE ASSEMBLY  
 Job Number : 34928  
 Estimate Number : 10254  
 P.O. Number : N/A Part Number : D212664101  
 This Issue : 10/2/2007 S.O. No. : N/A Drawing Number : D212-664-141 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : C  
 Previous Run : 33537 Material : N/A  
 Due Date : 10/30/2007 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : HA 07-10 02  
 Comment : Est Rev:E 04-02-16 Reformat KJ/DS  
 Est Rev:F 06-03-29 Remove Coments on Pick List JLM  
 Est Rev:G 07-04-30 As per Rev C JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 07/10/02

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101CHG003

G. Alula

2.0 D6005128 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6005-128 Crosstube B26549

Check OD = 2.750"; ID = 2.000"

J.F. 07/10/06

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA113

2-Turn first side as per Folio FA113

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141.

J.F. 07/10/08

~~07/10/08~~

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA113

J.F. 07/10/08

2-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141.

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/10/08

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/10/08

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

J.F. 07/10/08

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

Jb 7-10-10

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 07/10/08

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Jb 7-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 34928

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

EL 7-10-16

13.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

7-10-16 (1)

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

SR/EL 7-10-17

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

JD 7-10-19

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

JD 7-10-19

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EL 7-10-25

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 4916

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

C207110/24 (1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

C207110/300

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description:

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage &amp; ensure results are as per Dwg D212-664-141

07/10/30

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

07 10 30 } 07-10-31

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

ml 07 11 01 (1)

22.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1 Support

32779 ml 07 11 01

23.0

D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0840 sf(s)/Unit Total: 0.0840 sf(s)

Rubber Cushion (per sq ft)

.630" X 4.5" 4PCS

Batch: 35124

ml 07 11 05

24.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-25.06 Clamp

M106119

all see drawing attached pg. 1 ml 07 11 01

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description:

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: M104677

Expiry Date: 04/08

2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

Time: 400pm

ml 07-11-01

ml 07-11-05

①

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 7/11/06

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

PLACARD

Batch: ~~B34249~~ B34954

AS 07/11/07

29.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M104679

AS 07/11/07

30.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M105125

AS 07/11/07

31.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: M105125

AS 07/11/07

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DD Date: 01/11/09  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 34928

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch:

M104374

AS 02/11/07

33.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 02/11/07

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

AS 02/11/07

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 02/11/07

Job Completion



U 02/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 34928
<b>Description:</b> Crosstube Assembly (205/212/412 High Fwd)	<b>Part Number:</b> D212-664-141
<b>Inspection Dwg:</b> D212-664-141 <b>Rev:</b> C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

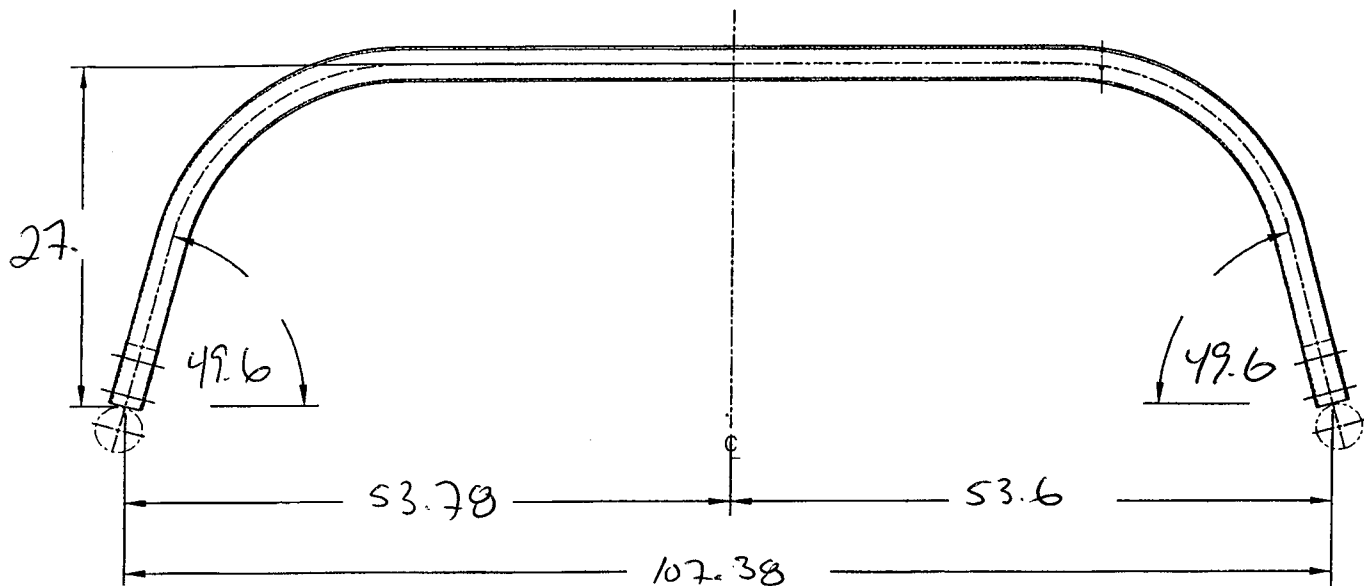
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	2.210"	✓		
	R0.063	+/-0.010	R0.063"	✓		
	2.740	+0.005/-0.000	2.744"	✓		
	5.097	+/-0.030	5.097"	✓		
	2.304	+0.005/-0.000	2.308"	✓		
	2.340	+0.005/-0.000	2.344"	✓		
	2.398	+0.005/-0.000	2.402"	✓		
	2.448	+0.005/-0.000	2.452"	✓		
	2.498	+0.005/-0.000	2.501"	✓		
	2.549	+0.005/-0.000	2.554"	✓		
	2.599	+0.005/-0.000	2.603"	✓		
	2.671	+0.005/-0.000	2.675"	✓		
	2.701	+0.005/-0.000	2.704"	✓		
SIDE B	0.200	+/-0.010	2.200"	✓		
	R0.063	+/-0.010	R0.063"	✓		
	2.740	+0.005/-0.000	2.745"	✓		
	5.097	+/-0.030	5.092"	✓		
	2.304	+0.005/-0.000	2.308"	✓		
	2.340	+0.005/-0.000	2.345"	✓		
	2.398	+0.005/-0.000	2.402"	✓		
	2.448	+0.005/-0.000	2.452"	✓		
	2.498	+0.005/-0.000	2.501"	✓		
	2.549	+0.005/-0.000	2.554"	✓		
	2.599	+0.005/-0.000	2.603"	✓		
	2.671	+0.005/-0.000	2.675"	✓		
	2.701	+0.005/-0.000	2.704"	✓		
	126.51	+/-0.020	126.510"	✓		

<b>Measured by:</b> J.F.	<b>Audited by:</b> JML	<b>Prototype Approval:</b> N/A
<b>Date:</b> 07/10/07	<b>Date:</b> 07/10/08	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM	
C	07.05.28	Dwg Rev updated	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	34928
<b>Description:</b> Crosstube High Fwd (205/212/412)	<b>Part Number:</b>	D212-664-101
<b>Inspection Dwg:</b> D212-664-141 <b>Rev:</b> C		Page 1 of 1

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	<i>[Signature]</i> 07-10-16
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

**DART**

DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>GP</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

**RELEASED**07.04.24 **[Signature]**

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

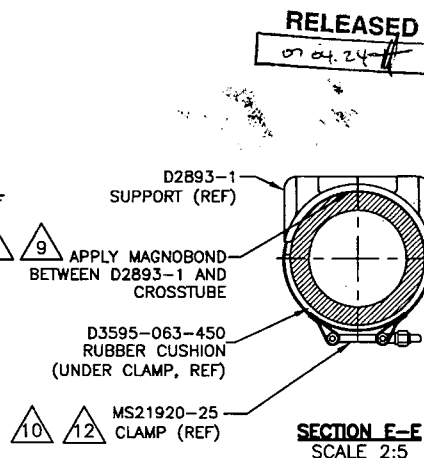
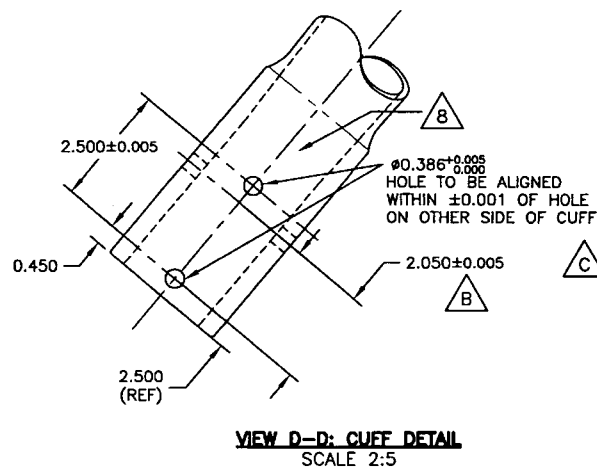
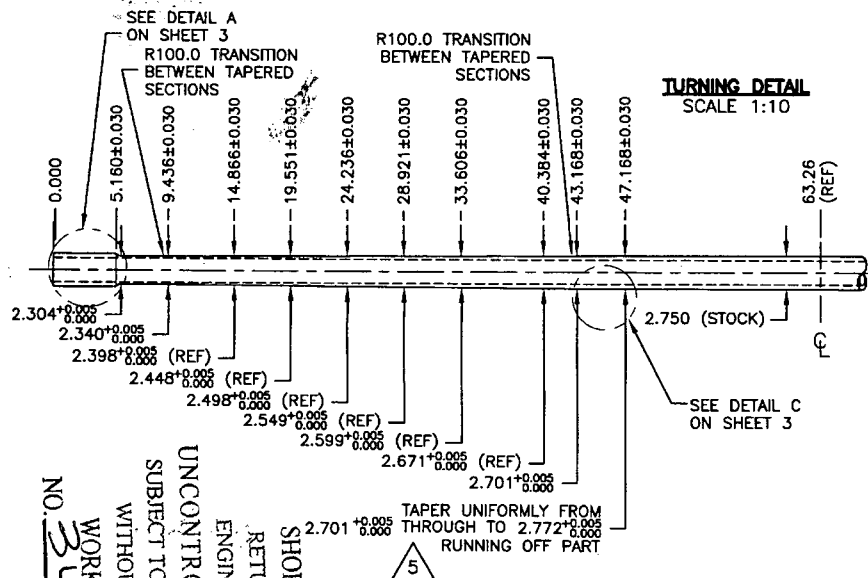
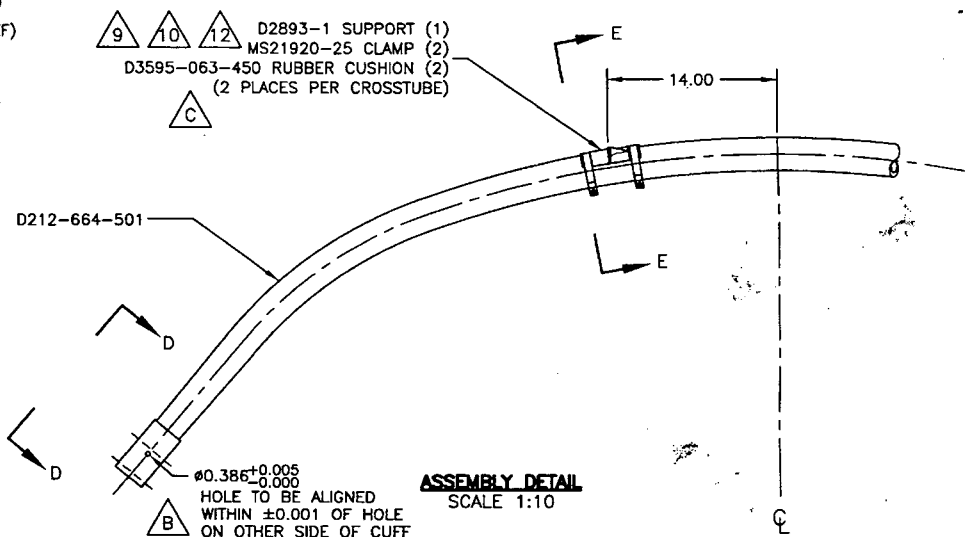
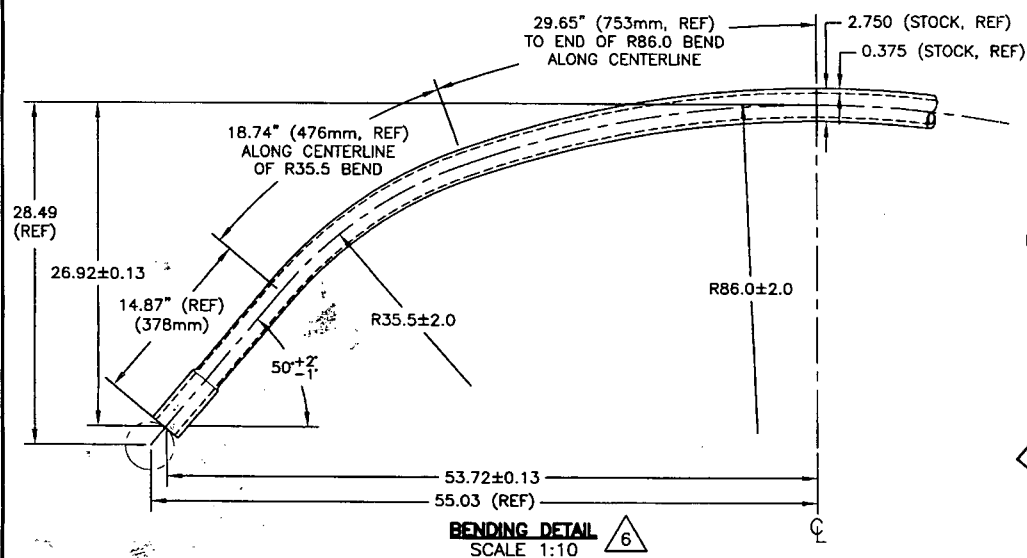
**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128  
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **34928**

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RELEASED  
07.03.08

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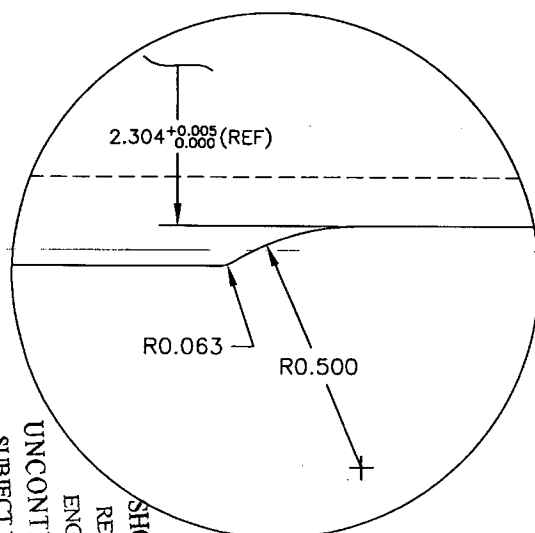
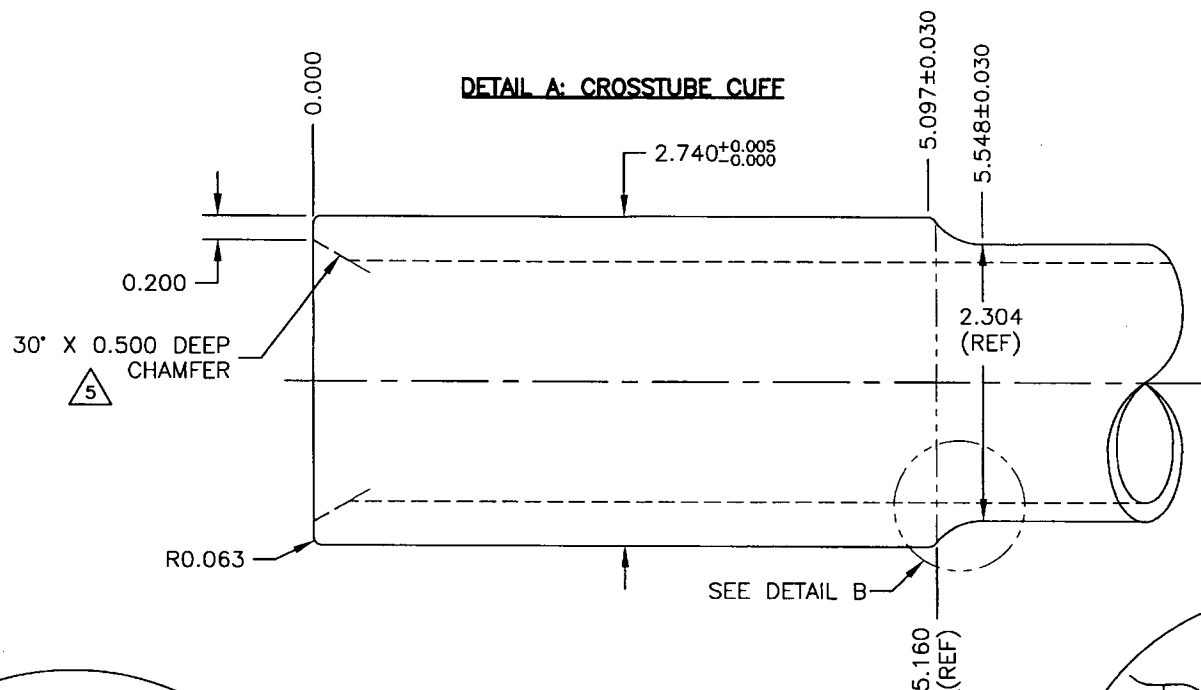
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DESIGN	PH	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. MIDLANDS, ONTARIO, CANADA
CHECKED	92	APPROVED	4	DRAWING NO.	REV. C
DATE	07.03.08	TITLE	XTUBE ASS'Y (205/212/412 HI. FWD)	D212-664-141	SHEET 2 OF 3
		SCALE	1:10		

NO. 34928  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
27.01.08

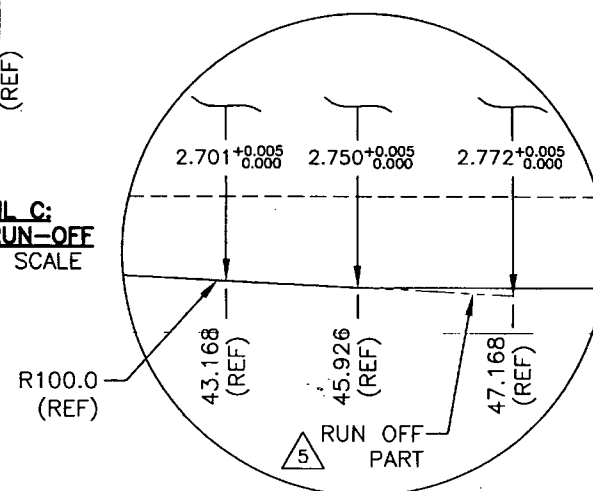


**RELEASED**  
 67.04.24 (P)  
 PER ELN 887



**DETAIL B: CUFF  
 TRANSITION**  
 SCALE 4:1

**DETAIL C:  
 TAPER RUN-OFF**  
 NOT TO SCALE



SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 34928

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 DART AEROSPACE LTD.

DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED J	APPROVED J	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:1



P. 09852

PT Sept 2005

